

Work Order ID 146892

Tuesday, May 24, 2016 9:59:50 AM

146892

Page 1

Item ID: D3589-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Assembly
 Start Date: 5/16/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/24/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: MAY 25 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3589	C								
100		0.00							
100									
Large Fab	Memo	4.96							
Large Fab	1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589								
	2- grind weld flush as per dwg D3589								
	3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589								
	*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***								
	4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004								
	ensure parts fit correctly on jig								
	A/R Stainless Steel Rod Batch: <u>123823</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

4 16-06-15
JR

① 16-06-16
 DAS
 9
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DQA: _____ Date: _____



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146892

Page 3

Item ID: D3589-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Assembly

Start Date: 5/16/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>7</u>	0.00							
150									
Packaging	Memo	0.04				4			880 JUN 20 2016
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							16/6/21 J
Quality Control									

MCS JUN 20 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
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							Completed By		
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OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 146892

146892

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 5/16/2016

Required Date: 5/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revise
process as per coss DD 10.01.18 verified by:EC IPP REV:C 12.07.23 AS
PER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3589-1		Manufactured	No			100	Each	4.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3589-1

Arm

16-06-14
Jm

Location	Loc Qty	Loc Code
WA002 146025	4	
144461	4	

4

D3589-11		Manufactured	No			100	Each	18.0000	1	4			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3589-11

Fwd Guide Plate

16-06-14
Jm

Location	Loc Qty	Loc Code
WA002	18	
137595	2	
145405	16	

4

D3589-13		Manufactured	No			100	Each	28.0000	2	8			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3589-13

Lug

16-06-14
Jm

Location	Loc Qty	Loc Code
WA002	28	
139003	28	

8

D3589-15		Manufactured	No			130	Each	31.0000	2	8			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3589-15

Link

JF

JUN 16 2016

Location	Loc Qty	Loc Code
WA002	31	
137716	31	

8

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____ _____ _____			

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Page 2

Work Order ID: 146892

146892

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 5/16/2016

Required Date: 5/24/2016

Start Qty: 4.00

Required Qty: 4.00

D3589-23

Manufactured No

100

Each

21.0000

2

8

D3589-23

Arm Guide

16-06-14
JMC

Location

Loc Qty

Loc Code

WA002

21

137072

1

144658

20

8

D3589-3

Manufactured No

130

Each

27.0000

2

8

D3589-3

Arm Guide

16-06-14
JMC

Location

Loc Qty

Loc Code

WA

27

144462

27

8

D3589-7

Manufactured No

100

Each

4.0000

1

4

D3589-7

Aft Guide Plate

16-06-14
JMC

Location

Loc Qty

Loc Code

WA002

4

139504

4

4

D3589-9

Manufactured No

100

Each

24.0000

1

4

D3589-9

Fwd Guide Plate

16-06-14
JMC

Location

Loc Qty

Loc Code

WA002

24

145706

24

4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Page 3

Work Order ID: 146892

Parent Item: D3589-041

Parent Item Name: Latch Assembly

146892

D3589-041

Start Date: 5/16/2016

Required Date: 5/24/2016

Start Qty: 4.00

Required Qty: 4.00

MS20392-1C7

Purchased

No

130

Each

100.0000

2

8

MS20392-1C7

Pin

**

FF

JUN 16 2016

Location

Loc Qty

Loc Code

ST314

100

m134488

100

8

MS24665-1010

Purchased

No

130

Each

208.0000

2

8

MS24665-1010

COTTER PIN

**

FF

JUN 16 2016

Location

Loc Qty

Loc Code

ST288

208

108335

192

114405

16

8

NAS1149DN432J

Purchased

No

130

Each

165.0000

4

16

NAS1149DN432.J

WASHER

**

FF

JUN 16 2016

Location

Loc Qty

Loc Code

CA

165

m129682

165

16

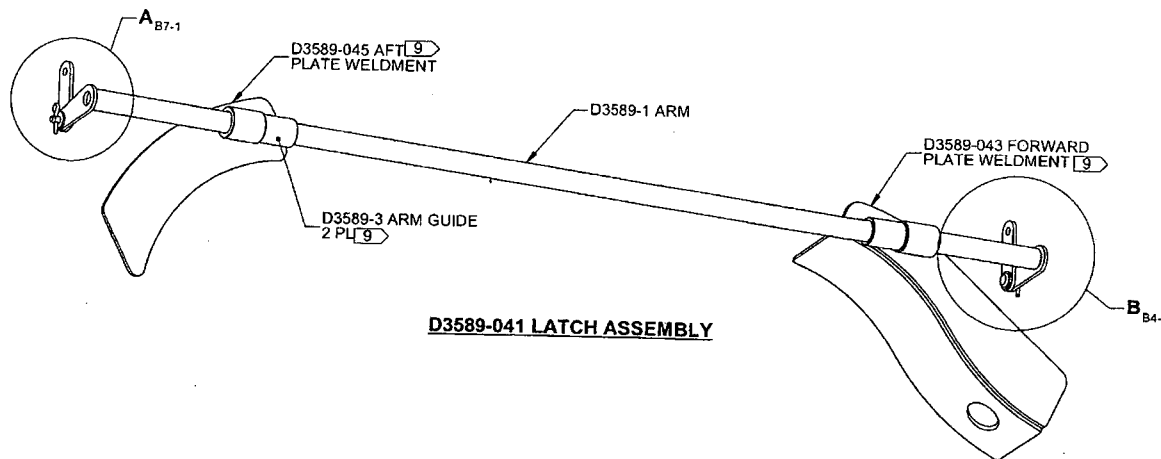
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

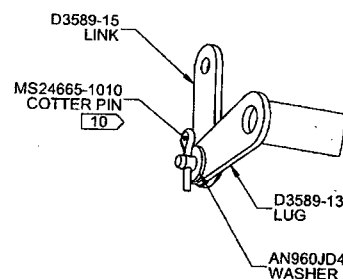
QA Closed: _____ Date: _____

Work Order update only ☐

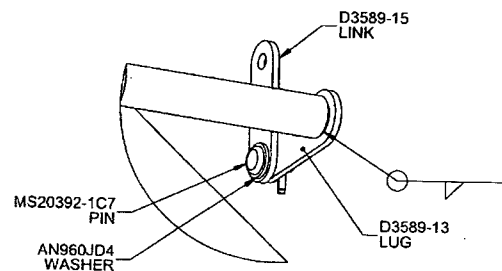
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**
SCALE 2X
2 PL

ITEM	QTY.	P/N	DESCRIPTION
	X	D3589-041	LATCH ASSEMBLY
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

FOR COPY
IN TO
ENGINEERING
CONTROLLED COPY
AND AMENDMENT
NOTICE
ON LINE

146892 MLS
16-0525

RELEASED
2012-07-16

C	REVISED D3589-5: 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4); AFFECTS D3589-047 (ZN A7-3) AND D3589-048 (ZN A3-3); REVISED D3589-15: Ø0.140 WAS Ø0.129 (ZN B4-7); 0.900 WAS 1.150 (ZN C4-7); ADDED D3589-23 (ZN C2-4); AFFECTS D3589-043/045 (ZN D7-2 AND D2-2); REASON: PART 12-177.	MB	12.07.04
B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.07.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3589

TITLE
LATCH ASSEMBLY

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- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 - 7) WEIGHT: 0.75 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540